

Work Order ID 67018

Thursday, March 03, 2011 11:53:08 AM



Page 1

Item ID: D3315-6

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

11-3-7

1010 . 003

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-3-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				(6)			
Brake NC	Memo	0.00		SB 11/03/09					
	1- Form using DT8751 Die as per Dwg D3315 Rev: <u>B</u>								
	2- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: <u>B</u>								
140 QC	QC6- Inspect dimensions to drawing	0.00				(46)			
Quality Control	Memo	0.00		5 11/03/09					
150 Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
	Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: <u>B</u>								
	Qty Part Number Description Batch								
	A/R N/A 7560 Hardcoat Rod <u>M116272</u>								

E 11-3-16 (46)

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Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/103/17

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/103/17

46

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M 115128

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50
3200
12:00

6 BL 11-3-17

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/03/11

200 Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3315-6, B/N: BXXXXX
For Product Eligibility see PDA04-17
and Stock
Location: 496A

11/3/17

210 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/17

11-03-17

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67068
Description: Wearplate		Part Number: D3315-6
Inspection Dwg: D3315	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	X		T (BU)	
30.215	+/-0.010	30.215	L		T	
24.215	+/-0.010	24.215	L		T	
21.611	+/-0.010	21.611	L		T	
17.965	+/-0.010	17.965	X		T	
16.026	+/-0.010	16.026	X		T	
14.735	+/-0.010	14.735	X		T	
12.815	+/-0.010	12.815	X		T	
6.465	+/-0.010	6.465	X		V HB02	
5.464	+/-0.010	5.466	*		✓	
4.527	+/-0.010	4.523	*		V	
3.550	+/-0.010	3.559	*		V	
5.214	+/-0.010	5.211	*		V	
Ø0.300	+0.006/-0.001	0.303	*		✓	
Ø0.266 x 0.575	+/-0.010	0.267 x 0.580	*		✓	
Ø0.266 x 0.450	+/-0.010	0.267 x 0.453	*		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-3-7	Date: 11/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	DD

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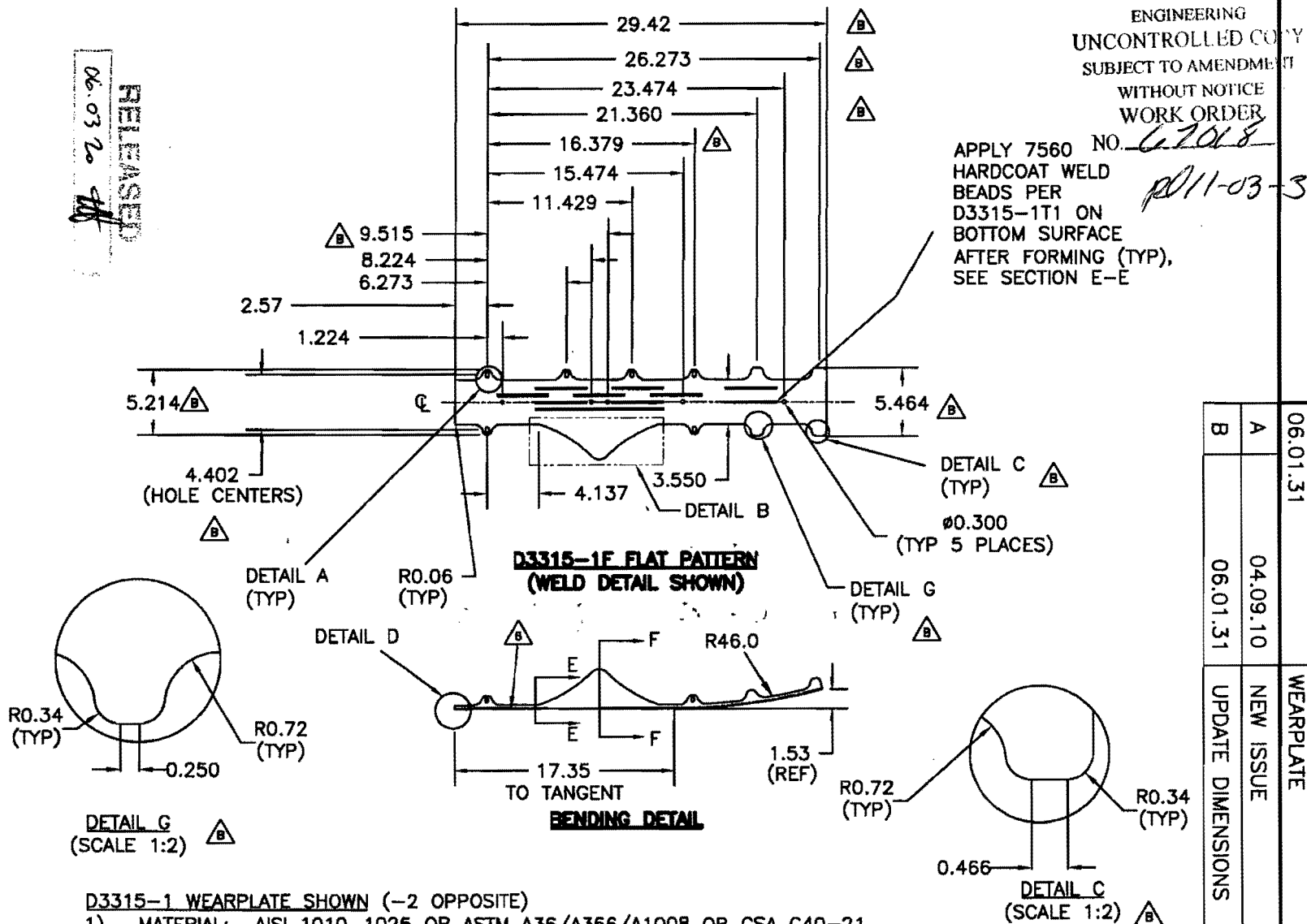
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
06.03.20



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

APPLY 7560 NO. 67018
HARDCOAT WELD BEADS PER D3315-1T1 ON BOTTOM SURFACE AFTER FORMING (TYP), SEE SECTION E-E

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
84	84	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 1 OF 4
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS
		SCALE 1:12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

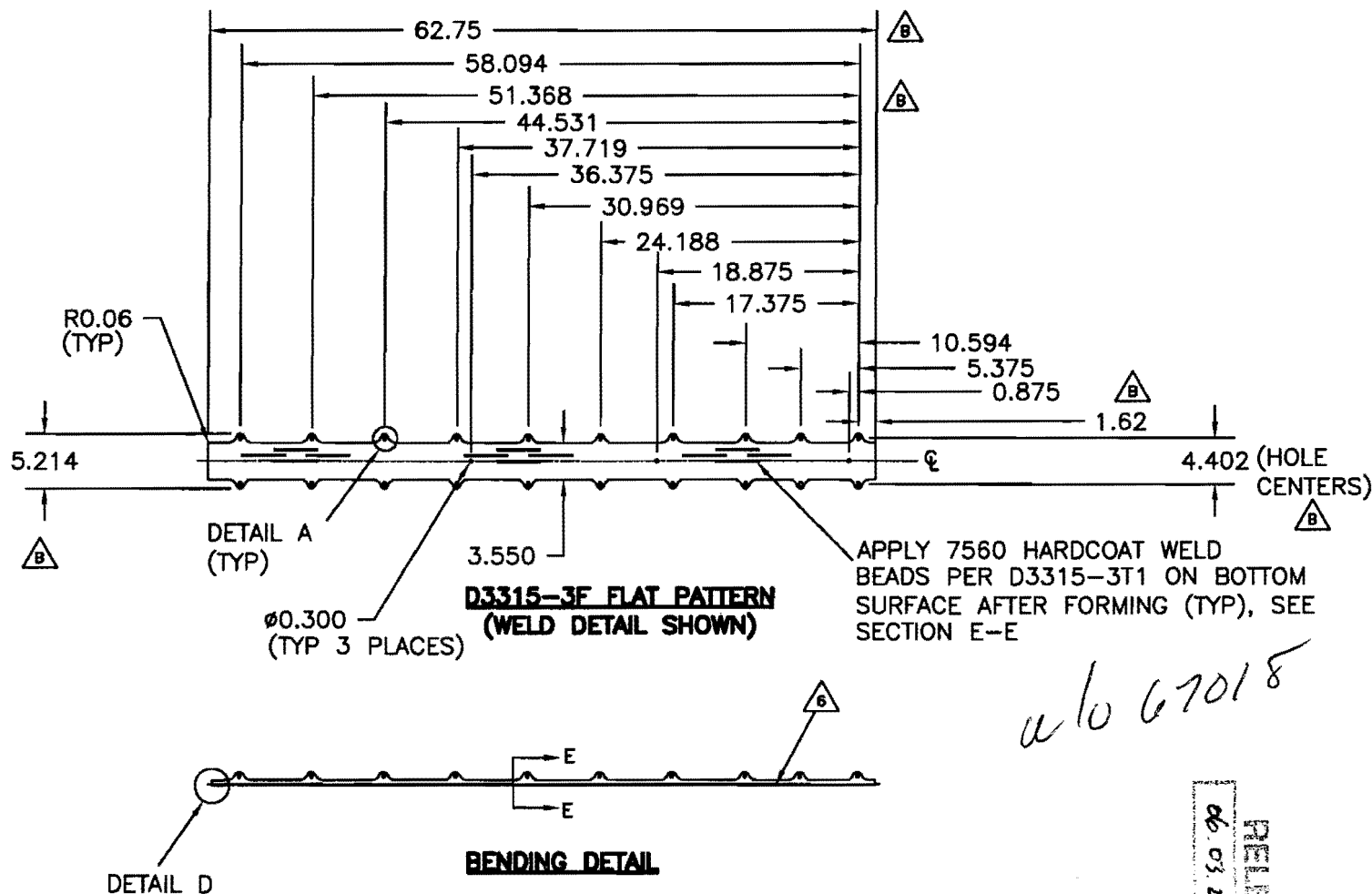
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 2 OF 4
		SCALE	1:16	



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

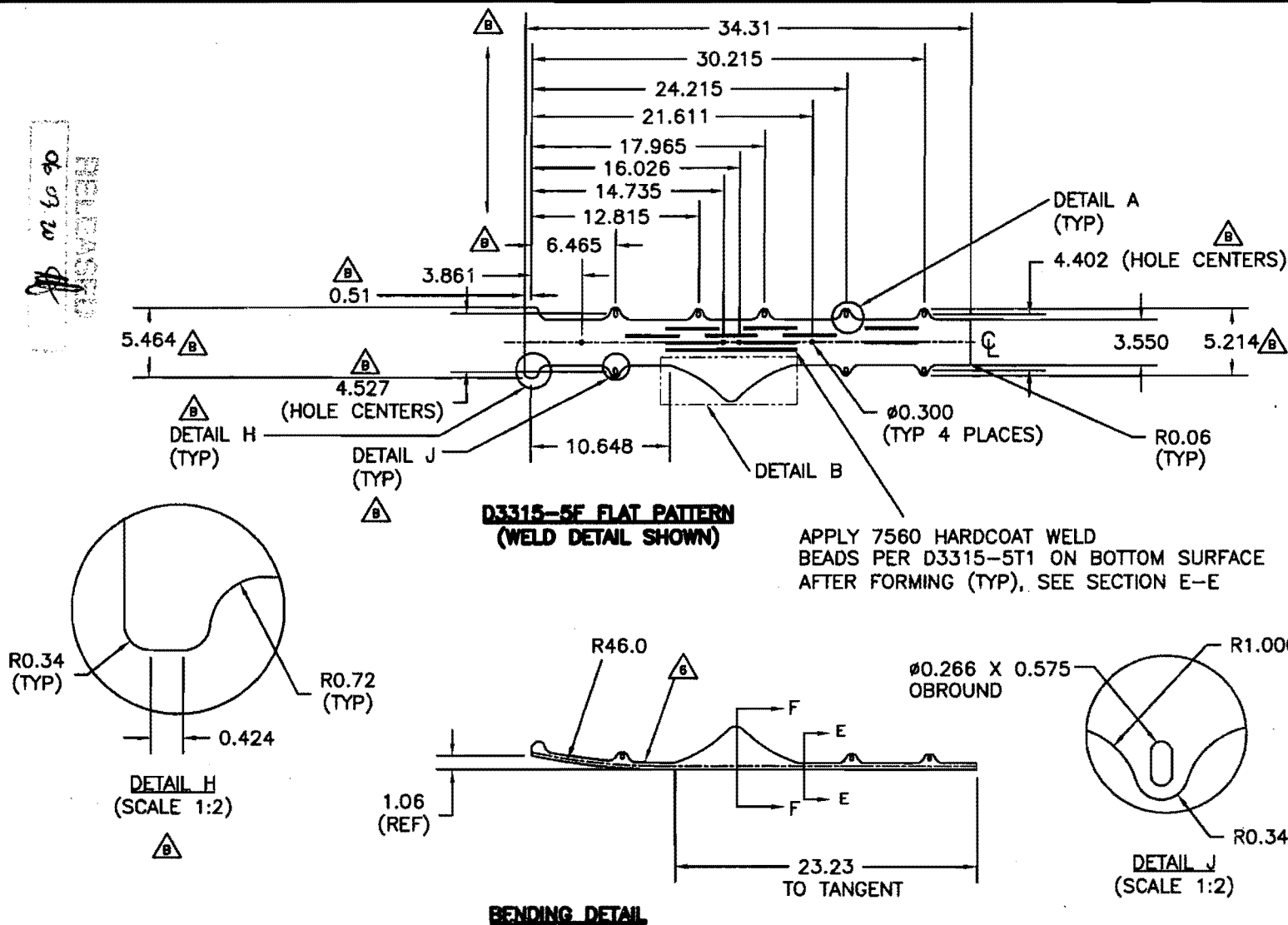
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 3 OF 4
		SCALE	1:12	



**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E

BENDING DETAIL

D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

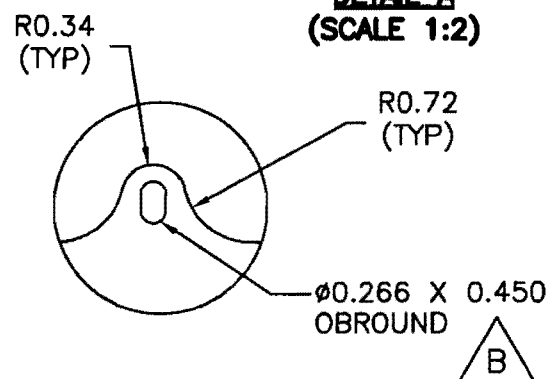
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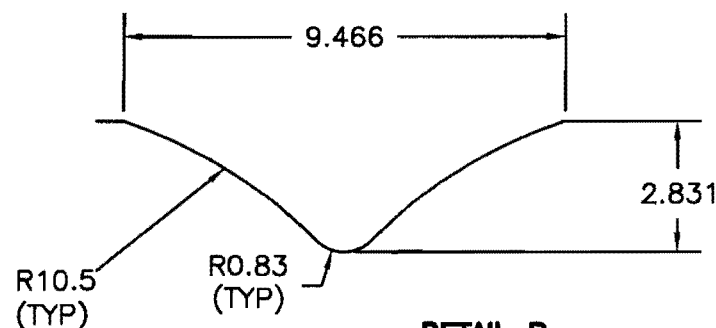
DART

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. B
DATE	06.01.31	TITLE	D3315	SHEET 4 OF 4
		WEARPLATE		SCALE NTS

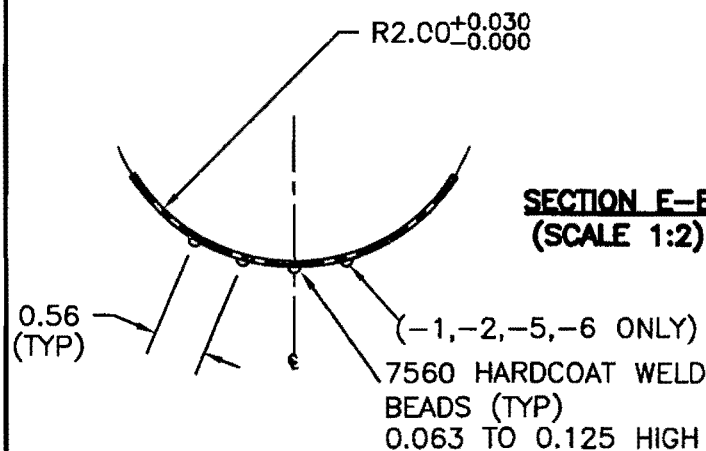
DETAIL A
(SCALE 1:2)



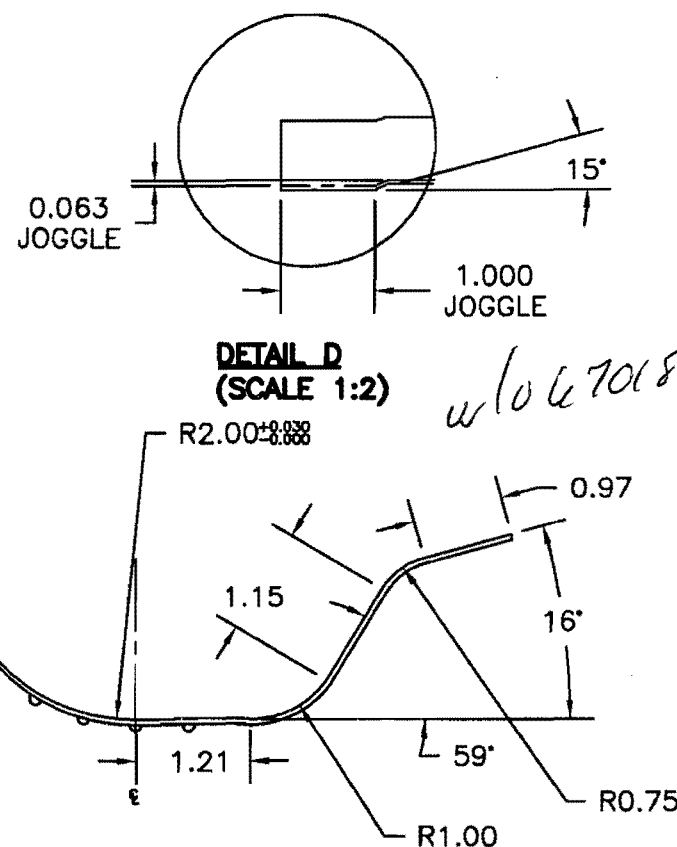
DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)



DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



06.03.20

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